

Work Order ID 73604

Wednesday, September 07, 2011 10:45:23 A



ASAP

Page 1

Item ID: D3183-9

Accept



Setup Start



Revision ID:

Item Name: Cap

Stop



Start Date: 9/8/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: UMF

Date: 11-09-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3183	Rev C1
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100	
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	Hardinge CNC LATHE SMALL
--	--------------------------

Hardinge	Memo
----------	------

Hardinge CNC Lathe Small	Turn D3183-9 Cap as per Folio FA388-1 Deburr
--------------------------	--

110	QC2- Inspect parts off machine FAI/FAIB
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	0.00
--	------

QC	Memo
----	------

Quality Control	0.00
-----------------	------

120	QC8- Inspect parts - second check
-----	-----------------------------------

	0.00
--	------

QC	Memo
----	------

Quality Control	0.00
-----------------	------

20 11-9-08 20

20 11-7-08 20

ank 110908

20 p

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73604

Wednesday, September 07, 2011 10:45:23 A



Page 2

Item ID: D3183-9

Accept



Setup Start



Revision ID:

Item Name: Cap

Stop



Start Date: 9/8/2011

Start Qty: 20.00



Cust Item ID:

Required Date: 9/8/2011

Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: ST 236Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

Memo

0.00

11-09-08

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 07, 2011 10:45:19 AM

Page 1

Work Order ID: 73604



Parent Item: D3183-9



Parent Item Name: Cap

Start Date: 9/8/2011

Required Date: 9/8/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A□ 06.05.03□ New issue□ KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000 		Purchased		No		100	f	41.2180	0.0333	0.701053 	<u>20</u>	<u>11. 9. 8</u>	

Delrin Round Bar 1"

Location	Loc Qty	Loc Code
MAT055	41.218	
117985	0.407	
118257 ✓	24.811	<u>606</u> /
118392	16	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

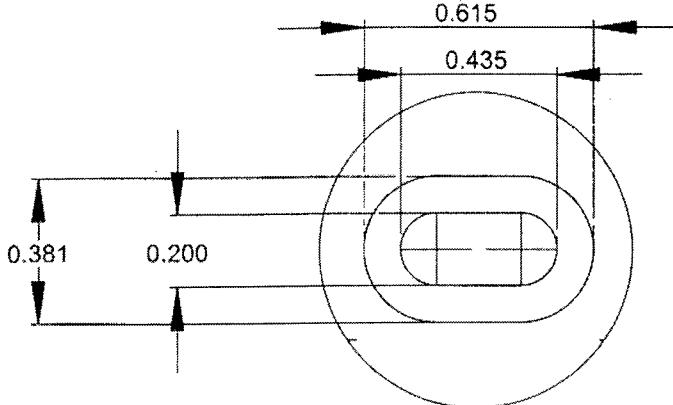
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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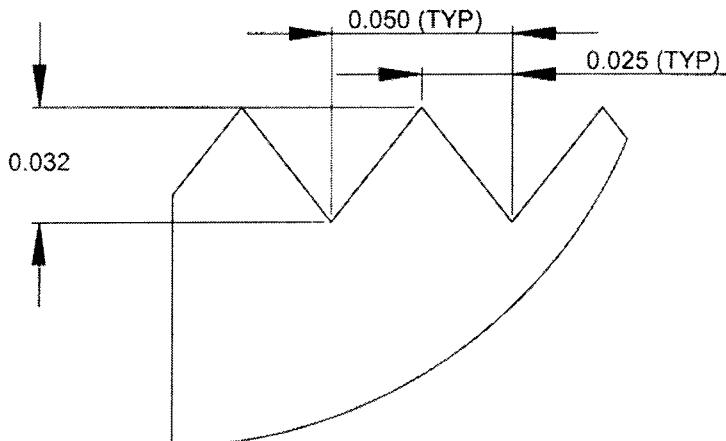
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 4 OF 4
DATE	04.02.17	TITLE	SCALE
		BRACKET ASSEMBLY	1:1



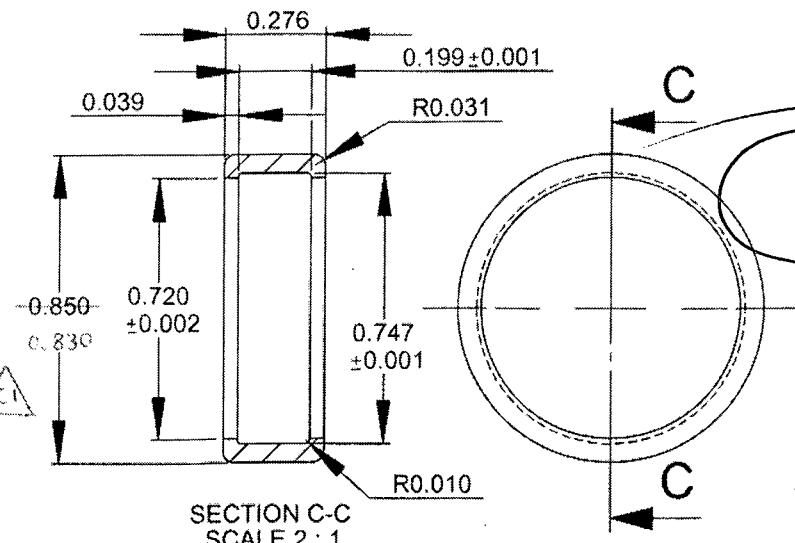
DETAIL A (2 : 1)

RELEASED
04.03.01

DEO ATTACHED



DETAIL B (20 : 1)



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00 (REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

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DRAWING NO. D3183	TITLE BRACKET ASSEMBLY	REV.C1	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3183-C1-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>gp</i>	CHECKED <i>JK</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>	DE APPR. <i>MP</i>		
DATE 10.05.14	DATE 10.06.30	DATE 10.06.30	DATE 10/06/30	DATE 10/06/30	DATE 10/06/30	

D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT: Cr = 1720 N (386 lb) MIN [DYNAMIC]
 Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012

*HOPCV**

RELEASED
 2010-07-22
MP

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DART AEROSPACE LTD	Work Order:	73609
Description: Cap	Part Number:	D3183-9
Inspection Dwg: D3183	Rev: C1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	RQ	Audited by:	ark	Prototype Approval:	N/A
Date:	11.9.08	Date:	11/09/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3183-045)	KJ/RF	
B	06.03.09	Dimension Ø0.830 was Ø0.850	KJ/JLM	

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